

Work Order ID 67828

Thursday, March 31, 2011 1:12:52 PM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/31/2011 Start Qty: 800

Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 800

Customer:

Reference:

Approvals: Process Plan: 11 Date: 11-03-31

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

100 0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

8/10/12

HJG BG 11-4-27

160 0.00



Packaging

Packaging

Pick Kit

Memo

11/04/27

170 0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

8/10/12

AO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67828

Thursday, March 31, 2011 1:12:52 PM

Page 2

Item ID: D350-578-011

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 3/31/2011 Start Qty: 8.00

Required Date: 4/4/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:



SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 011 □ Location: <u> </u>	D350-578-011 A							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF
11-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 1:12:58 PM

Page 1

Work Order ID: 67828



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 3/31/2011

Required Date: 4/4/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			160	Each	484.0000	12	96/20			JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		484							
				116419		184			116419				
				116704		300							
D2182B Rubber Cushion		Manufactured	No			160	f	362.7002	2.5	20 25			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST410		362.7002							
				63413		12.7002							
				66063		350			B66063				
Cut qty 6 at 5.00" long D2274 Radius Block		Manufactured	No			160	Each	160.0000	12	96/20			67578 X 1 JB 11/04/27
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		160							
				65757		160			65757 X 19				

S
AD

S
AD

S
AD

→ measured
5/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 1:12:58 PM

Page 2

Work Order ID: 67828

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 3/31/2011

Required Date: 4/4/2011

Start Qty: 8.00 / 0

Required Qty: 8.00

S
#10
D2432
206 (24") Bearpaw

Manufactured No

160 Each

1.0000

2

1630



67829 19X Lu

Location

Loc Qty

Loc Code

ST495

1

65302

1

68302 16 Lu

S
#10
D2438
Clamp

Manufactured No

160 Each

45.0000

6

4860



67830 X16 JB

Location

Loc Qty

Loc Code

ST456

45

66064

45

66064 X44
96/20

S
#10
D2529
Washer

Manufactured No

160 Each

641.0000

12



JB Lu

Location

Loc Qty

Loc Code

ST016

641

64127

141

66953

500

64127

S
#10
MS21042L4
Nut

Purchased No

160 Each

3,239.000

12

96/20



JB Lu 11/04/27

Location

Loc Qty

Loc Code

ST300

3239

116188

1239

116823

2000

116188

Thursday, March 31, 2011 1:12:59 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 1:12:59 PM

Page 3

Work Order ID: 67828



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 3/31/2011

Required Date: 4/4/2011

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

2,950.000

24

✓

192240



Washer



JB 11/04/27

Location

Loc Qty

Loc Code

FP-B

18

116805

18

ST298

2932

117065

2932

117065

Thursday, March 31, 2011 1:12:59 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

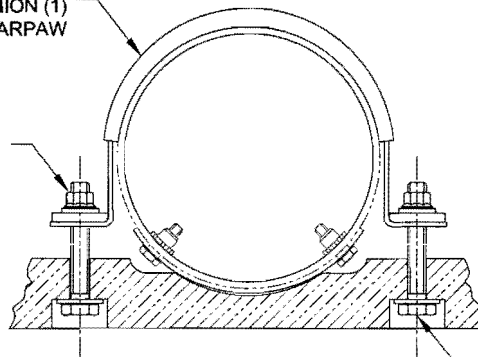
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



REFERENCE ONLY

ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

